

Date: Wednesday, 6/27/2007 1:08:23 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	CROSSBOLT SPACER		
Job Number	33221			Part Number	D2971		
Estimate Number	11632			Drawing Number	D2971 REV A1		
P.O. Number	N/A			Project Number	N/A		
This Issue	6/27/2007	S.Q. No.	N/A	Drawing Revision	A1		
Prsh Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	7/20/2007		
Previous Run	N/A			Qty:	10	Um:	Each
Written By							
Checked & Approved By	<u>J. Johnston 06.28</u>						
Comment	Est B 02.11.04 Re-format; Ø0.875" x 0.058" was Ø0.625" x 0.065" KJ						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TQ375W058	6061-T6 Tube .375 x.058W
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: Qty.: 0.2975 f(s)/Unit Total : 2.9747 f(s)
6061-T6 Tube .375 x.058W
Cut 6061-T6 (WW-T-700/6) Ø0.875" X 0.058" Wall
(M6061T6T0.875W.058)
Batch: M7950

Comment: HARDINGE CNC LATHE SMALL
as per Dwg D2971 & Folio FA288

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Comment: SECOND CHECK

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WS

DSP 07/07/09 (11)

DSP 07/07/09 (11)

07/07/09 (11)

C 07/07/09 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 1:08:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 33221

Part Number: D2971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



11

Comment: FINAL INSPECTION/W/O RELEASE

① 07/07/09

Job Completion



07/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

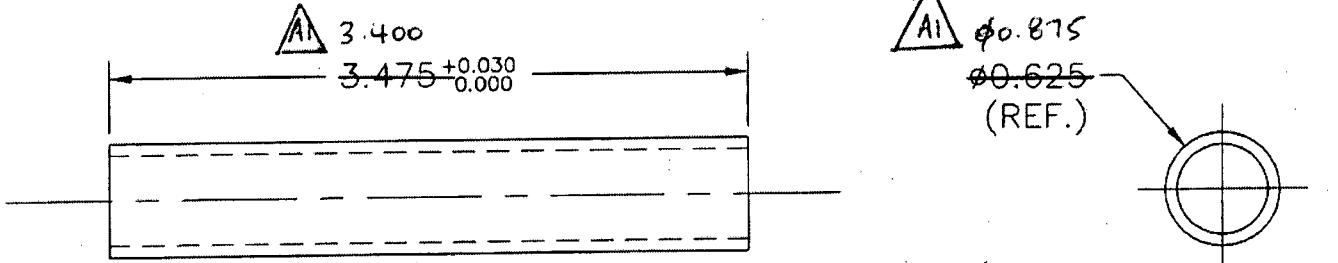
NOTE: Date & initial all entries



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CETCO

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2971	REV. A SHEET 1 OF 1
DATE 00.03.13		TITLE CROSS BOLT SPACER	SCALE 1:1
A	00.03.13	NEW ISSUE	
A1	4-17 02-10-30	CHANGE TO 0.875 OD X 0.058 WALL	

RELEASED
00.05.11



MATERIAL: 6061-T6 (WW-T-700/6) ~~0.625 DIA. X 0.065 WALL~~ **0.875 DIA. X 0.058 WALL** **AI** SHOP COPY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 33221

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DART AEROSPACE LTD	Work Order:	
Description:	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>DJP</u>	Audited by: <u>SG</u>	Prototype Approval:
Date: <u>07/07/09</u>	Date: <u>07-07-09</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	